

Date: Tuesday, 30/09/2008 11:14:20 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 42360		Part Number	: D2572		
Estimate Number	: 10531		Drawing Number	: D2572 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 30/09/2008	S.O. No.	Type	MACHINED PARTS	Drawing Revision	: E
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 17/10/2008		
Previous Run	: 41704		Qty:	17		
Written By	:		Um:	18 Each		
Checked & Approved By	: <u>Jul 08.9.20</u>					
Comment	: Est: 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D6101005	Saddle Billet
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B34874</u>
2.0	HAAS	HAAS CNC VERTICAL MACHINING #1
		 Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>42360</u> Double check by: <u>JL</u>
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		 Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See NCR 42359

Part No: D2572 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: A Date: 08.11.04
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 42360

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



JL 8/10/28

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



LB 28/10/28

16x

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-F 08/10/28

7.0 POWDER COATING POWDER COATING



16x

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:30

10:30

OVEN TEMPERATURE: 320° F

320° F

FINISH TIME: 11:00

11:00

M-F

08/10/30

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



17

Comment: INSPECT POWDER COAT

FZ 08/10/30

9.0 PACKAGING 1 PACKAGING RESOURCE #1



16x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 433

8/10/30

SP

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/11/03 20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 42360	
Description: Saddle, Fwd Inboard				Part Number: D2572	
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions					
				1	2	3	4	By	
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.001	8.000		
F	0.490	0.510		.501	.500	.501	.501		
G	0.257	0.262		.259	.259	.258	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.500	.501	.501		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.566	.567		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.492	1.493	1.495	1.494		
N	2.495	2.505		2.498	2.499	2.500	2.500		
O	3.869	3.879		3.869	3.872	3.874	3.874		
P	0.115	0.135		.124	.123	.126	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.129	.126	.126	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.238	.240	.240	.235		
W	0.115	0.135		.126	.129	.129	.126		
X	0.307	0.312		.311	.312	.311	.309		
Y	0.760	0.765		.760	.766	.760	.766		
Z	0.352	0.372		.358	.362	.359	.356		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.626	.626	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.222	.250	.249	.246		
AE	1.375	1.395		1.388	1.386	1.391	1.391		
AF	0.115	0.135		.130	.130	.130	.135		
AG	0.240	0.280		.278	.260	.260	.260		
AH	0.240	0.260		.248	.251	.249	.248		
AI	2.000	2.020		2.003	2.031	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	DM	/	SL	Audited by:	88
Date:	08/10/27	/	08/10/23	Date:	08/10/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SL

DART AEROSPACE LTD				Work Order:	42360
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	27	28		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.001		
F	0.490	0.510		.500	.500	.500	.503		
G	0.257	0.262		.260	.259	.260	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.500	.500	.491	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.558	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.493	1.494	1.495		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.871	3.871		
P	0.115	0.135		.128	.128	.129	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.251	.252		
S	0.115	0.135		.129	.130	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.966	2.960		
V	0.230	0.250		.236	.236	.239	.231		
W	0.115	0.135		.128	.130	.130	.127		
X	0.307	0.312		.308	.308	.308	.308		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.361	.365	.364	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.628	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.246	.249	.246		
AE	1.375	1.395		1.391	1.389	1.390	1.391		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.253	.250	.250		
AH	0.240	0.260		.248	.250	.250	.250		
AI	2.000	2.020		2.005	2.004	2.006	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>JNL</i>	Audited by:	<i>JP</i>
Date:	08/10/27	Date:	08/10/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JL</i>	<i>JL</i>

DART AEROSPACE LTD				Work Order:	42360
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				19	210	811	812		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	7.999	7.999		
F	0.490	0.510		.502	.502	.501	.501		
G	0.257	0.262		.260	.259	.260	.260		
H	0.375	0.380		.377	.377	.378	.377		
I	0.490	0.510		.503	.503	.498	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.571	.571	.561	.571		
L	1.174	1.184		1.179	1.179	1.178	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.494		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	3.869	3.879		3.872	3.872	3.871	3.872		
P	0.115	0.135		.130	.130	.130	.130		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.253	.253	.253		
S	0.115	0.135		.120	.130	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.966	2.966	2.959	2.960		
V	0.230	0.250		.240	.239	.240	.240		
W	0.115	0.135		.122	.125	.129	.130		
X	0.307	0.312		.316	.310	.309	.309		
Y	0.760	0.765		.766	.760	.760	.760		
Z	0.352	0.372		.357	.355	.363	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.636	.636	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.242	.244	.245	.247		
AE	1.375	1.395		1.391	1.392	1.389	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.255	.258	.256		
AH	0.240	0.260		.250	.249	.250	.250		
AI	2.000	2.020		2.004	2.004	2.003	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	gwf	Audited by:	88
Date:	08/10/27	Date:	08/10/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	gwf

3-20
052
0.1
10-100

DART AEROSPACE LTD				Work Order:	42360
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13	14	15	16		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	7.999	7.998	7.998		
F	0.490	0.510		.499	.502	.503	.499		
G	0.257	0.262		.260	.260	.260	.259		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.504	.502	.502	.504		
J	1.174	1.184		1.179	1.179	1.178	1.179		
K	0.558	0.578		.574	.571	.571	.571		
L	1.174	1.184		1.179	1.179	1.178	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.494		
N	2.495	2.505		2.499	2.499	2.500	2.499		
O	3.869	3.879		3.871	3.872	3.872	3.872		
P	0.115	0.135		.132	.130	.131	.131		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.253	.254	.254	.255		
S	0.115	0.135		.132	.134	.134	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.957	2.958		
V	0.230	0.250		.241	.240	.240	.240		
W	0.115	0.135		.130	.130	.131	.132		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.364	.364	.365		
AA	0.470	0.530		.500	.500	.500	.506		
AB	0.615	0.635		.629	.629	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.247	.244	.245	.247		
AE	1.375	1.395		1.391	1.390	1.390	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.255	.252	.255	.260		
AH	0.240	0.260		.250	.250	.251	.257		
AI	2.000	2.020		2.005	2.005	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	<i>Gnk</i>	Audited by:	<i>88</i>
Date:	<i>08/10/27</i>	Date:	<i>08/10/28</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>28</i>	<i>28</i>

42360

DART AEROSPACE LTD			Work Order:	42360
Description: Saddle, Fwd Inboard			Part Number:	D2572
Inspection Dwg: D2572 Rev. E			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	27	31	41	By	Date
A	0.438	0.443		.440					
B	1.745	1.755		1.750					
C	3.495	3.505		3.500					
D	1.745	1.755		1.750					
E	7.990	8.010		8.000					
F	0.490	0.510		.501					
G	0.257	0.262		.260					
H	0.375	0.380		.377					
I	0.490	0.510		.503					
J	1.174	1.184		1.179					
K	0.558	0.578		.571					
L	1.174	1.184		1.179					
M	1.490	1.500		1.495					
N	2.495	2.505		2.499					
O	3.869	3.879		3.872					
P	0.115	0.135		.131					
Q	0.115	0.135		.135					
R	0.240	0.260		.254					
S	0.115	0.135		.132					
T	0.178	0.198		.188					
U	2.940	2.980		2.958					
V	0.230	0.250		.240					
W	0.115	0.135		.127					
X	0.307	0.312		.309					
Y	0.760	0.765		.760					
Z	0.352	0.372		.363					
AA	0.470	0.530		.500					
AB	0.615	0.635		.625					
AC	0.053	0.073		.063					
AD	0.240	0.260		.248					
AE	1.375	1.395		1.390					
AF	0.115	0.135		.135					
AG	0.240	0.280		.258					
AH	0.240	0.260		.250					
AI	2.000	2.020		2.006					
AJ	0.023	0.043		.033					

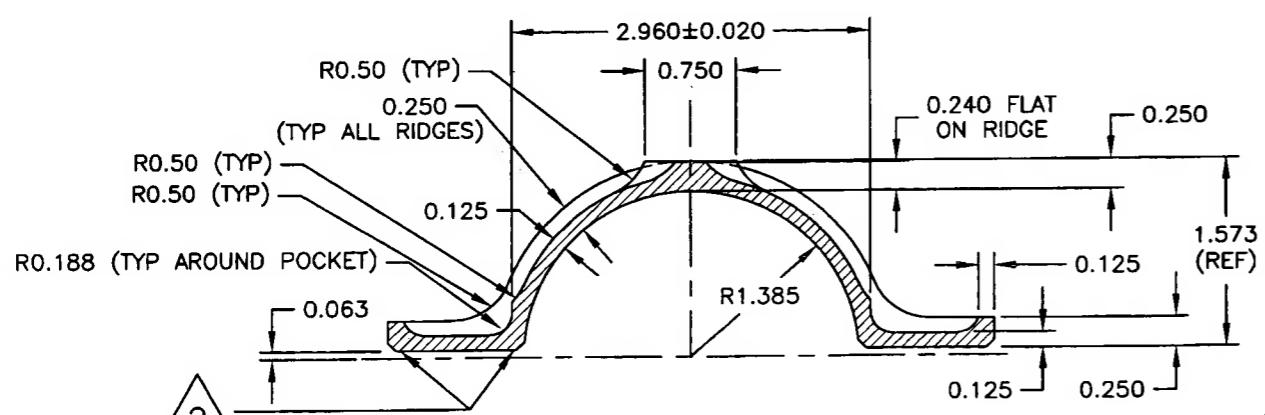
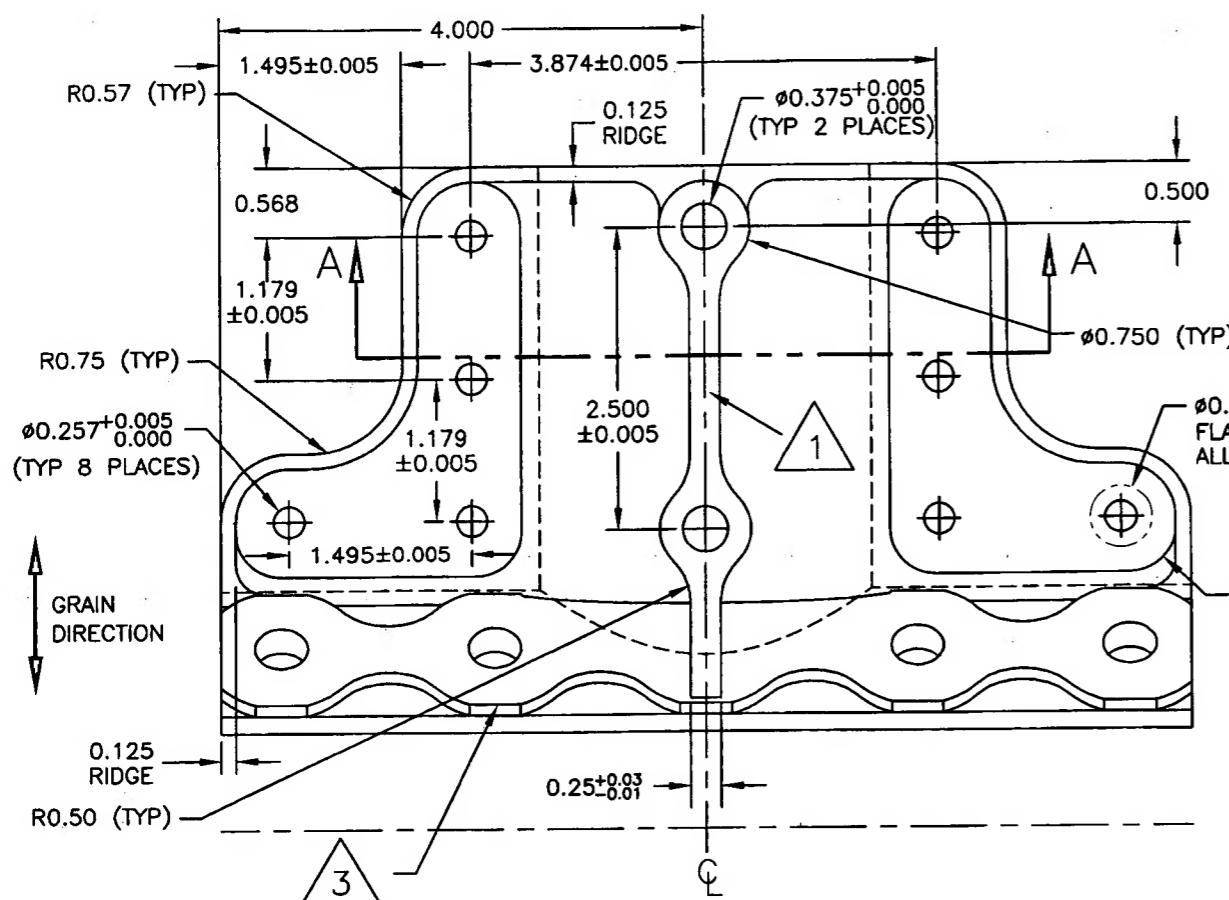
Accept/Reject

Measured by:	CMK	Audited by:	SB
Date:	08/10/27/	Date:	08/10/28

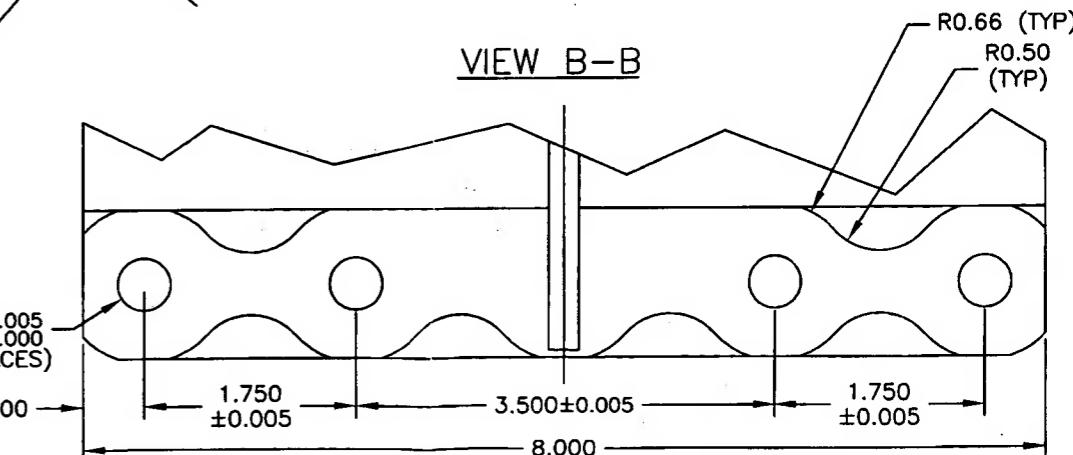
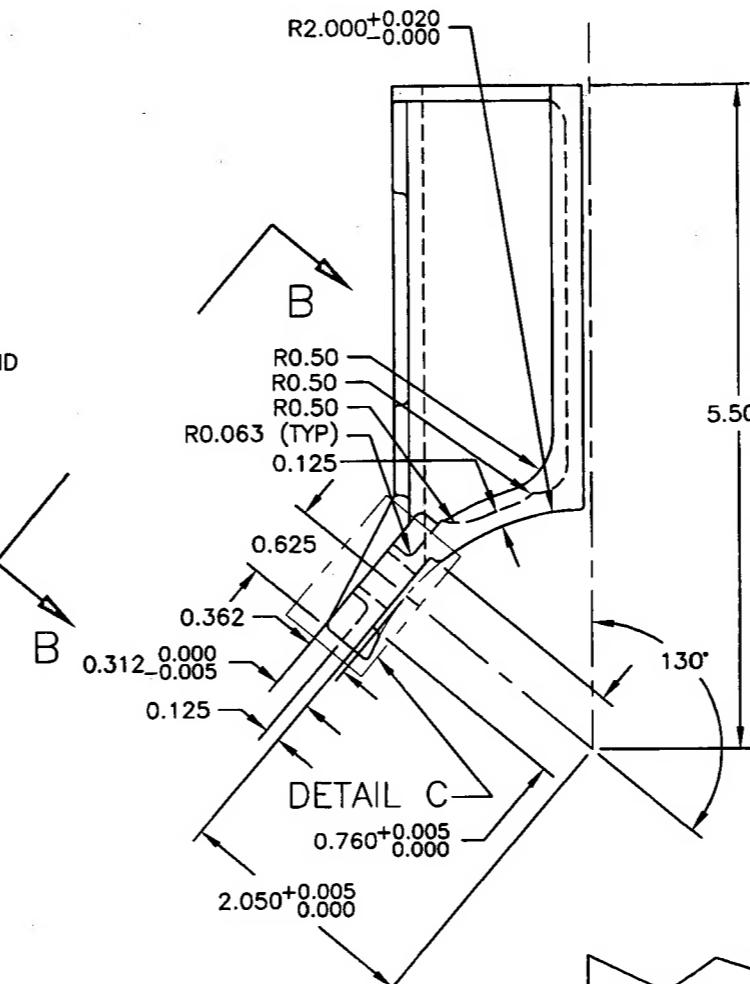
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	CMK

RELEASED

05.12.06



SECTION A-A
DETAIL C
SCALE 2:1



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

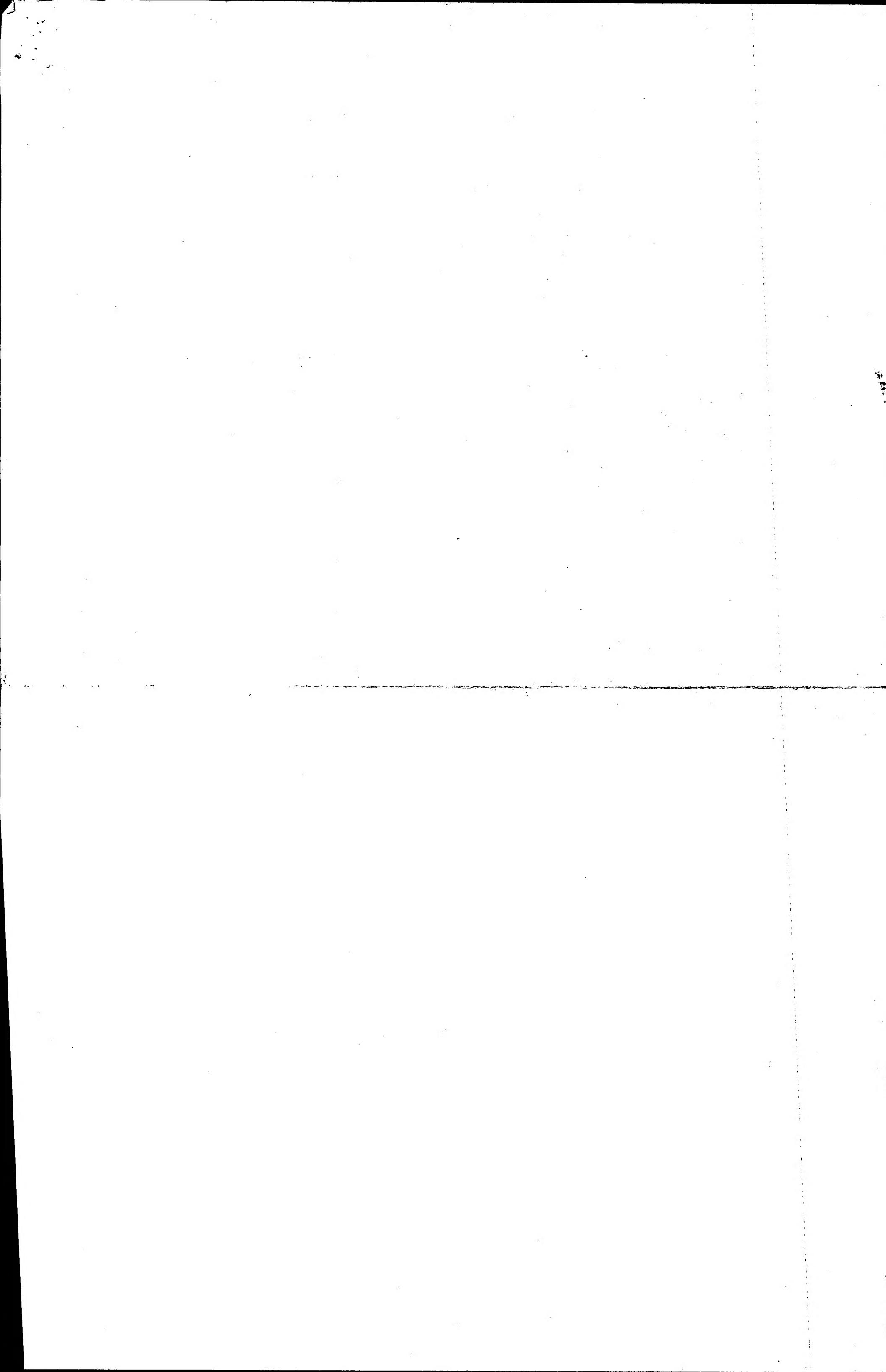
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)
- E

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DART AEROSPACE LTD.

DESIGN DS DRAWN BY PH DART DART AEROSPACE LTD. COPY
CHECKED APPROVED DRAWING NO. D2572
DATE 05.07.13 TITLE INNER FWD SADDLE
SUBJECT TSCALE
WITHOUT NOTICE
WORK ORDER
NO. 42300

ENGR/REV
SHEET NO. 1 OF 1
COPY
SUBJECT TSCALE
ENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42300



Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 23, 2008 1:56 PM
To: 'Chris Provencal'
Subject: RE: Emailing: NCR-D2571.jpg

Agree. Parts are acceptable.

David

-----Original Message-----

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, October 23, 2008 8:40 AM
To: 'David Shepherd'
Subject: Emailing: NCR-D2571.jpg

David,

D2751 & D2752, both and inner and outer saddle have the top ridge 0.220" (nominal = 0.250") under tolerance, see attached picture. I don't have anything to substantiate this by calculation. However, on the basis that the original saddle did not have this ridge, I would conclude that these saddles are acceptable. Do you concur?

-Chris

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.549 / Virus Database: 270.8.2/1739 - Release Date: 10/22/2008
7:23 AM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.549 / Virus Database: 270.8.2 - Release Date: 10/20/2008 12:00 AM

